

Date: Wednesday, 27/08/2008 3:15:28 PM  
 User: Julie Lecocq

## Process Sheet

Spit

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI-ACCESS STEP RH (FOLDING)
Job Number	: 41647-		
Estimate Number	: 12568		
P.O. Number	:	Part Number	: D412630034
This Issue	: 27/08/2008 S.O. No. :	Drawing Number	: IIN D412-630
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 27/08/2008 Type : LARGE FAB ASSY	Drawing Revision	: L
Previous Run	: 41244	Material	:
Written By	:	Due Date	: 10/09/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>JUL 08-8-26</u>		
Comment	: Est. Rev: A New Issue 06-11-08 JLM est rev B ecn1019, added D2807-041 EC verified by: DD		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; create labels per PPP D412-630-034 CHG003

S 09/01/15

2.0	D2012107	Clevis
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Clevis

Pick:

Qty	Part Number	Description	Batch
1	D2012-107	Clevis	40274

SS 09/01/12 (4)

3.0	D2803042	Bracket Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2803-042	Bracket Assembly RH	4167312

SS 09/01/12 (4)

4.0	D2804042	Bracket Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2804-042	Bracket Assembly RH	B 44492

SS 09/01/13

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Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 41647

Part Number: D412630034

Job Number:



Seq. #:	Machine Or Operation:	Description :								
5.0	D2807041	Door prop								
<p>Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)</p> <p>Support Prop</p> <p>Batch: <u>35751</u> <i>SS 09/01/12 (x4)</i></p>										
6.0	D2813	Washer								
<p>Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)</p> <p>Washer</p> <p>Pick:</p> <table border="0"> <tr> <td>Qty</td> <td>Part Number</td> <td>Description</td> <td>Batch</td> </tr> <tr> <td>2</td> <td>D2813</td> <td>Washer</td> <td><u>41667 x4</u> <u>34020 x4</u></td> </tr> </table> <p><i>SS 09/01/12 (x4)</i></p>			Qty	Part Number	Description	Batch	2	D2813	Washer	<u>41667 x4</u> <u>34020 x4</u>
Qty	Part Number	Description	Batch							
2	D2813	Washer	<u>41667 x4</u> <u>34020 x4</u>							
7.0	D3562042	Step Assembly, RH								
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)</p> <p>Step Weldment LH</p> <p>Pick:</p> <table border="0"> <tr> <td>Qty</td> <td>Part Number</td> <td>Description</td> <td>Batch</td> </tr> <tr> <td>1</td> <td>D3562-042</td> <td>Step Weldment RH</td> <td><u>B41039</u></td> </tr> </table> <p><i>EP 09/01/13</i></p>			Qty	Part Number	Description	Batch	1	D3562-042	Step Weldment RH	<u>B41039</u>
Qty	Part Number	Description	Batch							
1	D3562-042	Step Weldment RH	<u>B41039</u>							
8.0	D33951	Bushing								
<p>Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)</p> <p>Bushing</p> <p>Pick:</p> <table border="0"> <tr> <td>Qty</td> <td>Part Number</td> <td>Description</td> <td>Batch</td> </tr> <tr> <td>4</td> <td>D3395-1</td> <td>Bushing</td> <td><u>41669</u></td> </tr> </table> <p><i>SS 09/01/12 (x4)</i></p>			Qty	Part Number	Description	Batch	4	D3395-1	Bushing	<u>41669</u>
Qty	Part Number	Description	Batch							
4	D3395-1	Bushing	<u>41669</u>							
9.0	AN3C21A	BOLT								
<p>Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)</p> <p>BOLT</p> <p>Pick:</p> <table border="0"> <tr> <td>Qty</td> <td>Part Number</td> <td>Description</td> <td>Batch</td> </tr> <tr> <td>2</td> <td>AN3C21A</td> <td>Bolt</td> <td><u>M61189</u></td> </tr> </table> <p><i>SS 09/01/12 (x4)</i></p>			Qty	Part Number	Description	Batch	2	AN3C21A	Bolt	<u>M61189</u>
Qty	Part Number	Description	Batch							
2	AN3C21A	Bolt	<u>M61189</u>							

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Job Number:



Seq. #:	Machine Or Operation:	Description :
10.0	AN8C16	Bolt
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)		
Bolt		
Pick:		
Qty	Part Number	Description
2	AN8C16	Bolt
		Batch 105969 JS 09/01/12 (x4)
11.0	AN310C8	Nut
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)		
Nut		
Pick:		
Qty	Part Number	Description
2	AN310C8	Nut
		Batch M106431 JS 09/01/12 (x4)
12.0	MS24665302	Cotter Pin
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)		
Cotter Pin		
Pick:		
Qty	Part Number	Description
2	MS24665-302	Cotter Pin (or AN380C3-4)
		Batch M106763 JS 09/01/12 (x4)
13.0	NAS1515H3	Washer
Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)		
Washer		
Pick:		
Qty	Part Number	Description
6	NAS1515H3	Washer
		Batch M109268 JS 09/01/12 (x4)
14.0	NAS1515H5L	WASHER
Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)		
WASHER		
Pick:		
Qty	Part Number	Description
4	NAS1515H5L	Washer
		Batch M108964 x8 JS 09/01/12 (x4)



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Job Number: 41647

Part Number: D412630034

Job Number:



Seq. #:	Machine Or Operation:	Description :								
15.0	NAS1515H8	Washer								
<p>Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)</p> <p>Washer</p> <p>Pick:</p> <table border="0"> <tr> <td>Qty</td> <td>Part Number</td> <td>Description</td> <td>Batch</td> </tr> <tr> <td>4</td> <td>NAS1515H8</td> <td>Washer</td> <td>M109099</td> </tr> </table> <p>SS 09/01/12 (4)</p>			Qty	Part Number	Description	Batch	4	NAS1515H8	Washer	M109099
Qty	Part Number	Description	Batch							
4	NAS1515H8	Washer	M109099							
16.0	MS210433	Nut								
<p>Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)</p> <p>Nut</p> <p>Pick:</p> <table border="0"> <tr> <td>Qty</td> <td>Part Number</td> <td>Description</td> <td>Batch</td> </tr> <tr> <td>4</td> <td>MS21043-3</td> <td>Nut</td> <td>M110023 xH M109535 x5</td> </tr> </table> <p>SS 09/01/12 (4)</p>			Qty	Part Number	Description	Batch	4	MS21043-3	Nut	M110023 xH M109535 x5
Qty	Part Number	Description	Batch							
4	MS21043-3	Nut	M110023 xH M109535 x5							
17.0	MS24693C280	Screw								
<p>Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)</p> <p>Screw</p> <p>Pick:</p> <table border="0"> <tr> <td>Qty</td> <td>Part Number</td> <td>Description</td> <td>Batch</td> </tr> <tr> <td>2</td> <td>MS24693-C280</td> <td>Screw (or MS24694-C565)</td> <td>M101300</td> </tr> </table> <p>SS 09/01/12 (4)</p>			Qty	Part Number	Description	Batch	2	MS24693-C280	Screw (or MS24694-C565)	M101300
Qty	Part Number	Description	Batch							
2	MS24693-C280	Screw (or MS24694-C565)	M101300							
18.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1								
<p>Comment: SMALL &amp; MEDIUM FAB RESOURCE 1</p> <p>Assemble as per dwg D412-630 p.14</p> <p>Coat all hardware with LPS3 rust inhibitor</p> <p>A/R LPS3 batch: M109929</p> <p>COAT exposed HARDWARE WITH LPS PROCYON .</p> <p>A/R LPS PROCYON BATCH: M104251</p> <p>SS 09/04/13 (4)</p>										
19.0	QC5	INSPECT WORK TO CURRENT STEP								
<p>Comment: INSPECT WORK TO CURRENT STEP</p> <p>SS 09/01/13 (RH)</p>										

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Job Number: 41647

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation: Description :

20.0 PACKAGING 1 PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1  
Pick Packing Kit

21.0 D28061 Bushing

Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Bushing

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2806-1	Bushing	B35630

22.0 D28063 Bushing

Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Bushing

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2806-3	Bushing	B39058

23.0 D28105 Strut

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Strut

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D2810-5	Strut	B41029

24.0 D33961 Spacer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Spacer

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D3396-1	Spacer	B41670

25.0 AN4C6A Bolt

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN4C6A	Bolt	M107147

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Part Number: D412630034

Job Number:



Seq. #:	Machine Or Operation:	Description :
1	AN4C6A Bolt	
26.0	AN4C10A Bolt	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Bolt Pick: Packing Kit Qty Part Number Description Batch 1 AN4C10A Bolt M109679		
27.0	AN4C15A Bolt	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) Bolt Pick: Packing Kit Qty Part Number Description Batch 2 AN4C15A Bolt M107082		
28.0	AN44C7A Eyebolt	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Eyebolt Pick: Packing Kit Qty Part Number Description Batch 1 AN44-C7A Eyebolt M100446		
29.0	AN5C15A Bolt	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) Bolt Pick: Packing Kit Qty Part Number Description Batch 2 AN5C15A Bolt M105125		
30.0	NAS1515H4 Washer	
Comment: Qty.: 7.0000 Each(s)/Unit Total : 28.0000 Each(s) Washer Pick: Packing Kit Qty Part Number Description Batch 7 NAS1515H4 Washer M108880 9/1/14		



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Drawing Name: HELI-ACCESS STEP RH (FOLDING)

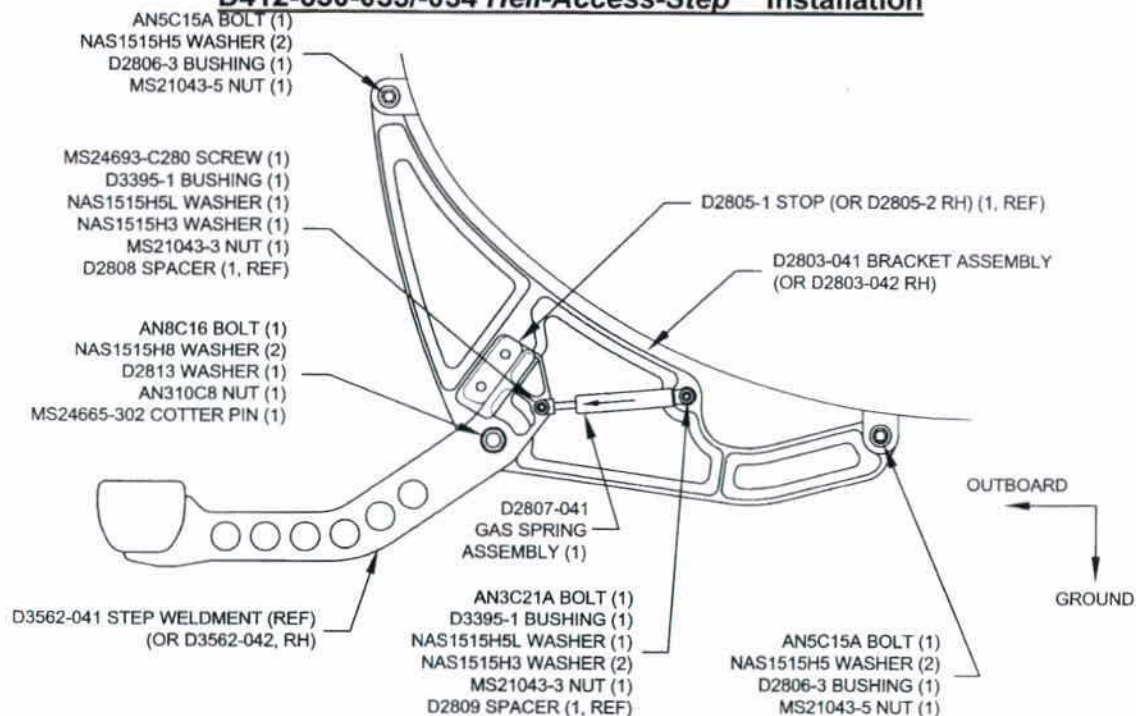
Job Number: 41647

Part Number: D412630034

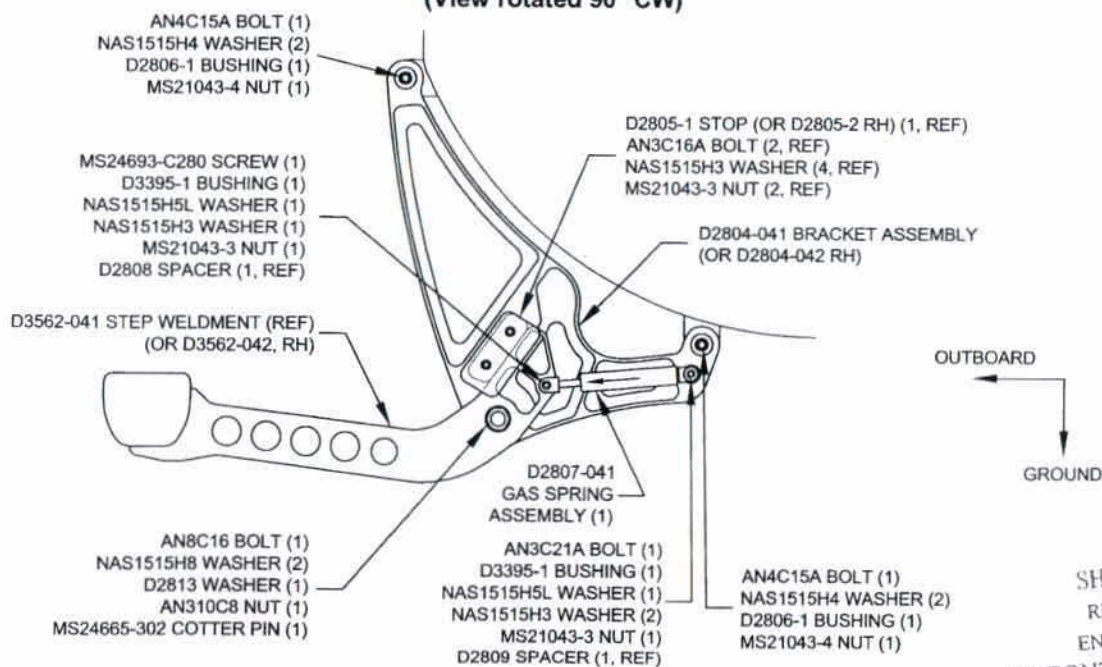
Job Number:



Seq. #:	Machine Or Operation:	Description :
31.0	NAS1515H5	Washer
 		
Comment: Qty.: 7.0000 Each(s)/Unit Total : 28.0000 Each(s)		
Washer		
Pick: Packing Kit		
5	Qty Part Number	Description Batch
	7 NAS1515H5	Washer M105728
32.0	MS210434	Nut
 		
Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)		
Nut		
Pick: Packing Kit		
5	Qty Part Number	Description Batch
	4 MS21043-4	Nut M109166
33.0	MS210435	Nut
 		
Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)		
Nut		
Pick: Packing Kit		
5	Qty Part Number	Description Batch
	3 MS21043-5	Nut M109535 9/6/14
34.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
 		
Comment: INSPECT 100% KITS FOR COMPLETENESS		
502/01/15 (1/210)		
35.0	PACKAGING 1	PACKAGING RESOURCE #1
 		
Comment: PACKAGING RESOURCE #1		
Identify and pack for shipping as per PPP D412-630-034		
Location: _____		
PPP Rev: <u>A</u> 9/6/15 (1)		
36.0	QC21	FINAL INSPECTION/W/O RELEASE
 		
Comment: FINAL INSPECTION/W/O RELEASE		
09/01/15 H		
Job Completion		
W 09/01/15		

**D412-630-033/-034 Heli-Access-Step™ Installation**

**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation**  
(View rotated 90° CW)



**FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation**  
(View rotated 90° CW)

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Date: 07.09.30

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